

Work Order ID 58466

May 7, 2010 9:45:41 AM

Ship Monday 10/10



Page 1

Item ID: D407-558-045

Accept



Setup Start



Revision ID:

Stop



Item Name: Single Cargo Mirror Assembly

Start Date: 5/07/10 Start Qty: 2.00



Cust Item ID:

Required Date: 5/10/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and type labels as per PPP D407-558-045 and DSI 9436 CHG001

0.00

Pick K.T

10-5-11

SP (2)

110



Small Fab

Small Fab

Small Fab

Memo

Assemble as per Dwg D206-558

0.00

0.00

SP 10/05/10 (2)

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

SP 10/05/10

(2)

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Page 2

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Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

8/10/10

12

Quality Control

140

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D407-558-045 and DSI 9436 Location: 42 PPP Rev: A

10-5-11 24
10-5-11

150

QC21- Final Inspection - Work Order Release

0.00



QC


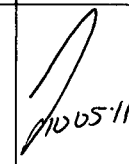
Memo

0.00

Quality Control

ME
10-5-11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/5/11	100	Parts missing. ADD part to kit MS35489-67 M 11193 Qty 4/ Per K.I. - 501514	SL	10-5-11	24	 10/5/11	S 10/5/11
		-update BOM w/lo Also ADD Partin numbers and place them in the correct order ADD copy of BOM for Ref.	AA	10.05.12		 10/05/11	S 10/5/11

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Quality System Instruction 012

INSPECTION

Procedure Issue Date: 08.04.01 Issue No.: 13

1.0 PURPOSE

To establish the method and authorities for inspection

2.0 SCOPE

This work instruction applies to all products at every stage of production, and gives the authorities at present for every type of inspection.

3.0 RESPONSIBILITY

3.1 DIRECTOR, QUALITY ASSURANCE

Is responsible for auditing that the inspections are being done in accordance with the QSI, and to ensure that the QSI is updated as responsibilities and employees change.

Picklist Print

May 7, 2010 9:45:37 AM

Page 1

Work Order ID: 58466

Parent Item: D407-558-045

Parent Item Name: Single Cargo Mirror Assembly

Comments: IPP Rev:A 09-01-15 new issue DD verified by:ec

Start Date: 5/07/10

Required Date: 5/10/10

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
AN3-4A Bolt		Purchased	No				Each	1.430.000	4	10-5-11		

Location

ST350

104214

104291

104322

104374

104625

104817

Loc Qty

1430

269

300

200

200

300

161

Loc Code

AN526-1032R9

Purchased

No



Screw

Location

ST328

113928

114382

Loc Qty

126

1

125

Each

Loc Code

AN960JD10

Purchased

No



Washer

AN960JD10L

Purchased

No



Washer

Location

ST348

110985

Loc Qty

4299

4299

Loc Code

Picklist Print

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Page 2

Work Order ID: 58466

Parent Item: D407-558-045

Parent Item Name: Single Cargo Mirror Assembly

Comments: IPP Rev:A 09-01-15 new issue DD verified by:ec

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Required Date: 5/10/10

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

D2011-101



6" Mirror

Manufactured

No

Each

2.0000

1



EP 5/10/05/10

Location

Loc Qty

Loc Code

ST228

2

56795

2

Each

20.0000

2



EP 5/10/05/10

D2052



Mounting Bracket

Manufactured

No

Location

Loc Qty

Loc Code

ST005

20

56290

20

Each

4.0000

1



4
10-5-11 sl

D2053



Mounting Bracket

Manufactured

No

Location

Loc Qty

Loc Code

ST005

4

47595

4

Each

4.0000

2



EP 5/10/05/10

D2054



Bushing

Manufactured

No

Location

Loc Qty

Loc Code

ST005

4

56291

4

3
358392 (14)

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Shop Packet Print

Page 2

Picklist Print

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Work Order ID: 58466

Parent Item: D407-558-045

Parent Item Name: Single Cargo Mirror Assembly

Comments: IPP Rev:A 09-01-15 new issue DD verified by:ec

Start Date: 5/07/10

Required Date: 5/10/10

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D2055 Clamp		Manufactured	No				Each	4.0000	1		5/10/05/10 B58393 (W)	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ST005				4				
					55726			4				
D2056 Bell Crank		Manufactured	No				Each	0.0000	1		5/10/05/10	
D2057 Plug		Manufactured	No				Each	9.0000	1		585 14.	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ST006				9			5/10/05/10	
					57039			9			2	
D2065 Arm		Manufactured	No				Each	6.0000	1		5/10/05/10	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ST229				6			2	
					56303			6				
D2067 Connector		Manufactured	No				Each	16.0000	1		10-5-11 SP (2X)	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ST006				16			2	
					54698			16				

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Shop Packet Print

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Picklist Print

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Page 4

15

Work Order ID: 58466

Parent Item: D407-558-045

Parent Item Name: Single Cargo Mirror Assembly

Comments: IPP Rev:A 09-01-15 new issue DD verified by:ec

Start Date: 5/07/10

Required Date: 5/10/10

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

D2071-3
Cable

Manufactured No

Each 2.0000 1

Location

Loc Qty

Loc Code

ST222

2

45004

2

Each 24.0000 1

10-5-11 sl

D3778-1
Bracket

Manufactured No

Location

Loc Qty

Loc Code

ST227

24

56316

24

Each 1,673.000 2

2

MS21042L3
Nut

Purchased No

Location

Loc Qty

Loc Code

ST300

1673

113537

20

113644

653

114523

1000

Each 1,673.000 2

8/10/05/10

MS21042L3
Nut

Purchased No

Location

Loc Qty

Loc Code

ST300

1673

113537

20

113644

653

114523

1000

2

10-5-11 sl

(24)

May 7, 2010 9:45:39 AM

Shop Packet Print

Page 4

Picklist Print

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Page 5 / 5

Work Order ID: 58466

Parent Item: D407-558-045

Parent Item Name: Single Cargo Mirror Assembly

Comments: IPP Rev:A 09-01-15 new issue DD verified by:ec

Start Date: 5/07/10

Required Date: 5/10/10

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

MS21919-DG5 12 Purchased

No

Each

24.0000

2

10-5-11 SD



Clamp

Location

Loc Qty

Loc Code

ST306

24

114348

24

MS27039-1-18 Purchased

No

Each

87.0000

2

4



Screw

Location

Loc Qty

Loc Code

ST292

87

113845

87

EP 10/05/10
4

May 7, 2010 9:45:40 AM

Shop Packet Print

Page 5

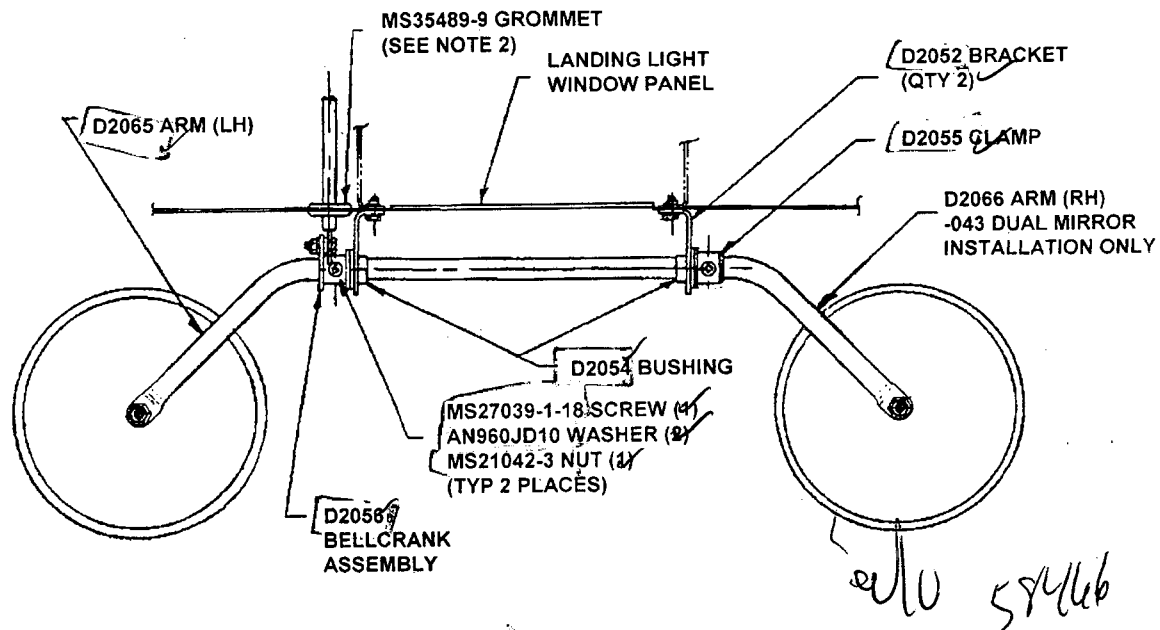


Figure 25.2 - View A: Looking Aft.
(D206-558-043 Mirror Shown)

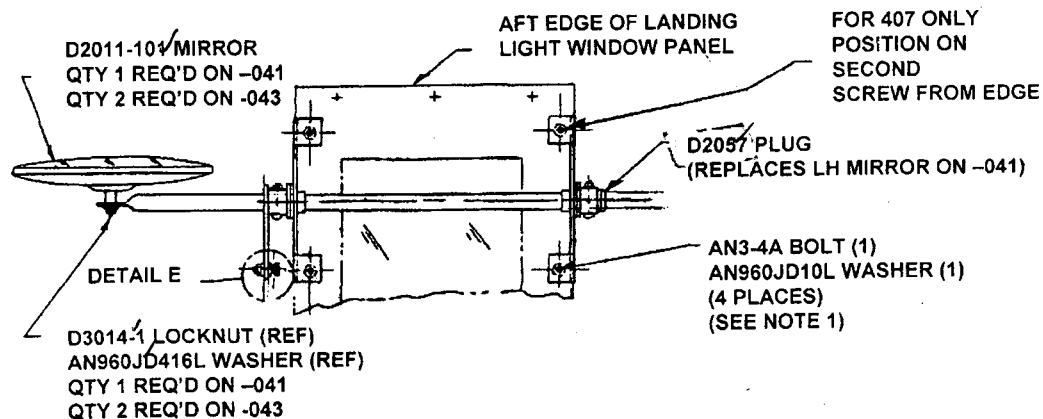


Figure 25.3 - View C: Looking Down on Mirror Installation
(D206-558-041 Mirror Shown)

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25-00-00

Work Order ID 58466

May 7, 2010, 9:45:41 AM

ship Monday 10/10



Page 1

Item ID: D407-558-045

Accept



Setup Start



Revision ID:

Item Name: Single Cargo Mirror Assembly

Stop



Start Date: 5/07/10 Start Qty: 2.00



Cust Item ID:

Required Date: 5/10/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100



DC

Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

Photocopy bluefile and type labels as per PPP D407-558-045 and DSI 9436
CHG001

CL101511

110



Small Fab

Small Fab

Small Fab

0.00

Memo

0.00

Assemble as per Dwg D206-558

5/10/05/10 (2)

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

5/10/05/10

(42)

REFERENCE ONLY

REFERENCE ONLY

FROM THIS POINT FORWARD, CUSTOMERS SHOULD ORDER D407-558-045/047 IN LIEU OF D206-558-041/043 WHEN PROCURING SINGLE/DUAL MIRRORS FOR BHT 407 MODIFICATIONS. AMEND SECTIONS 4.0 AND 5.0 OF INSTALLATION INSTRUCTIONS D206-558 REV. C OR EARLIER AND 25.3 AND 25.4 OF ICA-D206-558 REV. 0 AS FOLLOWS:

4.0 WEIGHT AND BALANCE (D206-558 REV. C OR EARLIER)

25.3 WEIGHT AND BALANCE (ICA-D206-558 REV. 0)

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D206-558-041	2.4 lb	+5.0 in	+12.0 in-lb	+14.8 in	+35.5 in-lb
Bell 206A/B/L/L1/L3/L4	1.09 Kg	+0.13 m	+0.14 m-Kg	+0.38 m	+0.41 m-Kg
D206-558-043	3.0 lb	0.0 in	0.0 in-lb	+14.8 in	+44.4 in-lb
Bell 206A/B/L/L1/L3/L4	1.36 Kg	0.0 m	0.0 m-Kg	+0.38 m	+0.52 m-Kg
D407-558-045	2.4 lb	+5.0 in	+12.0 in-lb	+14.8 in	+35.5 in-lb
Bell 407	1.09 Kg	+0.13 m	+0.14 m-Kg	+0.38 m	+0.41 m-Kg
D407-558-047	3.0 lb	0.0 in	0.0 in-lb	+14.8 in	+44.4 in-lb
Bell 407	1.36 Kg	0.0 m	0.0 m-Kg	+0.38 m	+0.52 m-Kg

5.0 PARTS LIST (D206-558 REV. C OR EARLIER)

25.4 PARTS LIST (ICA-D206-558 REV. 0)

Qty -041	Qty -043	Qty -045	Qty -047	Part Number	Description
				D206-558-041	SINGLE CARGO MIRROR ASSEMBLY
	X			D206-558-043	DUAL CARGO MIRROR ASSEMBLY
		X		D407-558-045	SINGLE CARGO MIRROR ASSEMBLY
			X	D407-558-047	DUAL CARGO MIRROR ASSEMBLY
1	2	1	2	D2011-101	MIRROR ASSEMBLY
2	2	2	2	D2052	BRACKET
1	1	1	1	D2053	BRACKET
2	2	2	2	D2054	BUSHING
1	1	1	1	D2055	CLAMP
1	1	1	1	D2058	BELLCRANK ASSEMBLY
1		1		D2057	PLUG
1		1		D2065	ARM
	1		1	D2066	ARM
1	1	1	1	D2067	CONNECTOR
1	1			D2071	CABLE ASSEMBLY
		1	1	D2071-3	CABLE ASSEMBLY
	2	1	2	D3014-1	* LOCKNUT
	1	1	1	D3779-1	BRACKET
	4	4	4	AN3-4A	BOLT
	4	4	4	AN525-1032R9	SCREW
1	2	2	2	AN939JD416E	* WASHER
4	4	4	4	AN939JD10	WASHER
6	6	6	6	AN939JD10L	WASHER
3	3	3	3	MS21042-3	NUT (or MS21042L3) -2
2	2	2	2	MS21919DG5	CLAMP
2	2	2	2	MS27039-1-18	SCREW
1	1			MS35489-9	GROMMET
		1	1	MS35489-67	GROMMET

* INCLUDED AS PART OF D2011-101 MIRROR ASSEMBLY

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
OAG 100-100

APPROVED
[Signature]
D. J. LEPEN (DE #02)

DATE: 08.12.04
CERT. NO.: SH92-17
ISSUE NO.: 7

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	DSI 9436	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries